


Work Order ID 76494

76494

Page 1

Tuesday, November 15, 2011 3:59:21 PM

Item ID: D3324-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 11/15/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/25/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan:  Date: 11/15/15 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***


| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3324 | Rev B |

100 0.00
100 Large Fab
 Large Fab
 Large Fab
 Memo
 1-Cut tubes as per Dwg D3324

| Qty | Part Number | Description | Batch |
|-----|-------------|------------------|----------------|
| 3 | D3324-1 | Bottom Tube | <u>4119404</u> |
| 4 | D3324-3 | Full Length Tube | <u>4119404</u> |
| 2 | D3324-5 | Top End Tube | <u>4119404</u> |
| 2 | D3324-7 | Bottom End Tube | <u>4119404</u> |
| 10 | D3324-9 | Vertical Tube | <u>4119404</u> |

 2- Weld as per dwg
 A/R 4130 rod batch 4118875

 11/11/25 (1x)

110 0.00
110 QC9- Inspect visual per QSI004- Fusion Welds
 QC
 Quality Control
 Memo
 0.00

1 0 2E11-11-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 76494***76494***

Page 2

Tuesday, November 15, 2011 3:59:21 PM

Item ID: D3324-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Base Assembly

Start Date: 11/15/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

121

Pressure Wash per QSI005 4.3

0.00

121

HandFinish

Memo

0.00

Hand Finishing

IXP M-11/11/28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Page 3

Tuesday, November 15, 2011 3:59:21 PM

Item ID: D3324-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly

Start Date: 11/15/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/25/2011 Req'd Qty: 1.00 ***1*** Customer:

Reference: Run Start ***NR1***
 Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Stop ***NR2***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|-----------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------|
| 130 *130* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | <i>NO m/11/11/28</i> |
| | Memo 1ST COAT: <i>3:10</i> START TIME: <i>4:00</i> OVEN TEMPERATURE: <i>400°F</i> FINISH TIME: <i>3:40</i> ***** 2nd coat if necessary ***** 2ND COAT: <i>3:50</i> START TIME: <i>4:00</i> OVEN TEMPERATURE: <i>400°F</i> <i>Finish time: 4:20</i> | 0.00 | | | | | | | |
| 140 *140* QC Quality Control | QC3- Inspect Part Finish | 0.00 | | | | | | | <i>1 11-11-28</i> |
| | Memo | 0.00 | | | | | | | |

m118434

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 4

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Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|-------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Identify as per dwg & Stock Location: <i>GA</i> | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo <i>W/O 76490 (ix)</i> | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Signature *11/11/29* *(ix)*

11/11/29 *MF*

MF
11-11-29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, November 15, 2011 3:59:25 PM

Page 1

Work Order ID: 76494

76494

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3328-3

Manufactured

No

100

Each

18.0000

2

2

**

11/11/23

✓*D3328-3*

Basket Hinge

Location

Loc Qty

Loc Code

WA005

18

33872

18

D3348-1

Manufactured

No

100

Each

15.0000

4

**

11/11/23

✓*D3348-1*

Clevis

Location

Loc Qty

Loc Code

WA

14

75575

14

WA005

1

44246

1

D3349-3

Manufactured

No

100

Each

4.0000

2

2

**

B75620 11/11/23

D3349-3

Spacer Bushing

Location

Loc Qty

Loc Code

WA

4

72930

4

D3367-1

Manufactured

No

100

Each

8.0000

2

2

**

B76500 11/11/23

D3367-1

Mounting Bracket

Location

Loc Qty

Loc Code

WA005

8

43228

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, November 15, 2011 3:59:26 PM

Work Order ID: 76494

76494

Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

✓ M4130NTS0.500W.035

Purchased

No

100 f

307.3682 46.6 49.05263

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

** B119683 → 49.0526

Location

Loc Qty

Loc Code

MAT034

307.3682

109127

158.152

109385

15.75

112786

39.2488

119441

57.8774

119506

36.34

11/11/25

✓ M569EX0.50-18F

Purchased

No

100 sf

146.0000 28 28

M569EX0 50-18F

569 Expanded Metal

** *11/11/21*

Location

Loc Qty

Loc Code

MAT018

146

112776

10

117806

4

119226

4

119404

128

32x

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

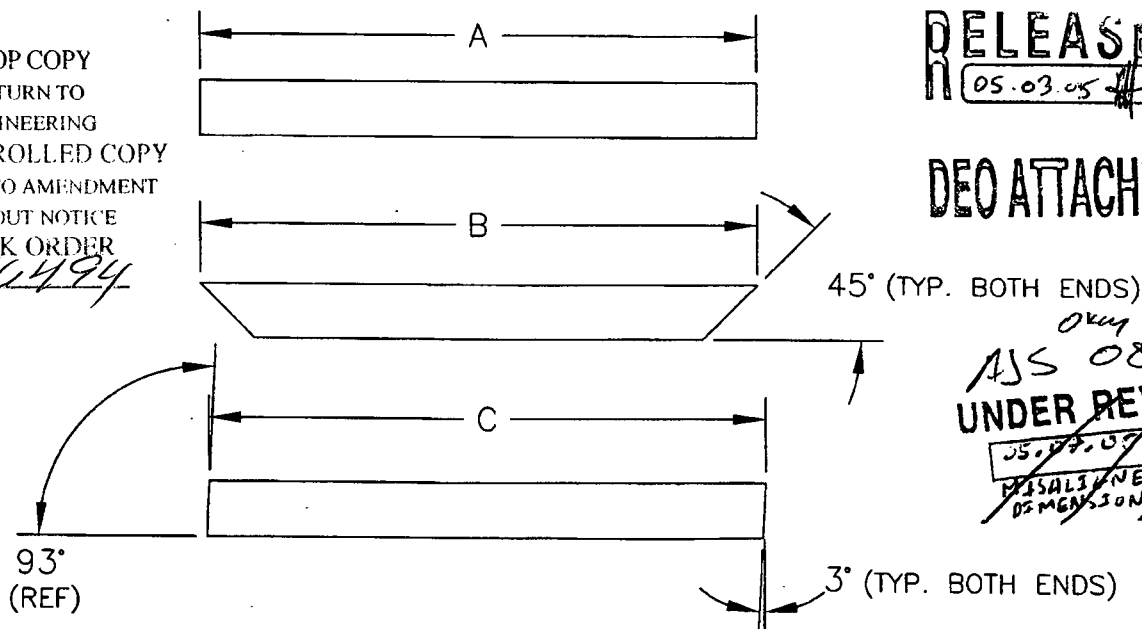
DART

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|---------------------|-----------------------|----------------------------------------------------------|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3324 | REV. B SHEET 1 OF 3 |
| DATE 05.03.04 | | TITLE BASKET BASE ASSEMBLY | SCALE NTS |
| A | 04.10.20 | NEW ISSUE | |
| B | 05.03.04 | UPDATE MESH MATERIAL SPEC | |

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

| Part No. | Quantity (-041) | Length A | Length B | Length C | Description |
|----------|-----------------|----------|----------|----------|------------------|
| D3324-1 | 3 | 14.00 | N/A | N/A | BOTTOM TUBE |
| D3324-3 | 4 | N/A | 86.50 | N/A | FULL LENGTH TUBE |
| D3324-5 | 2 | N/A | 16.00 | N/A | TOP END TUBE |
| D3324-7 | 2 | N/A | 15.00 | N/A | BOTTOM END TUBE |
| D3324-9 | 10 | N/A | N/A | 11.04 | VERTICAL TUBE |
| D3328-3 | 2 | N/A | N/A | N/A | HINGE PLATE |
| D3348-1 | 4 | N/A | N/A | N/A | CLEVIS |
| D3349-3 | 2 | N/A | N/A | N/A | SPACER BUSHING |
| D3367-1 | 2 | N/A | N/A | N/A | MOUNTING BRACKET |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70494



RELEASED
05.03.05 **#**

DEO ATTACHED

OK
155 08.12.15
UNDER REVIEW
05.07.07 **PH**
MISALIGNED
DIMENSION PG 2

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

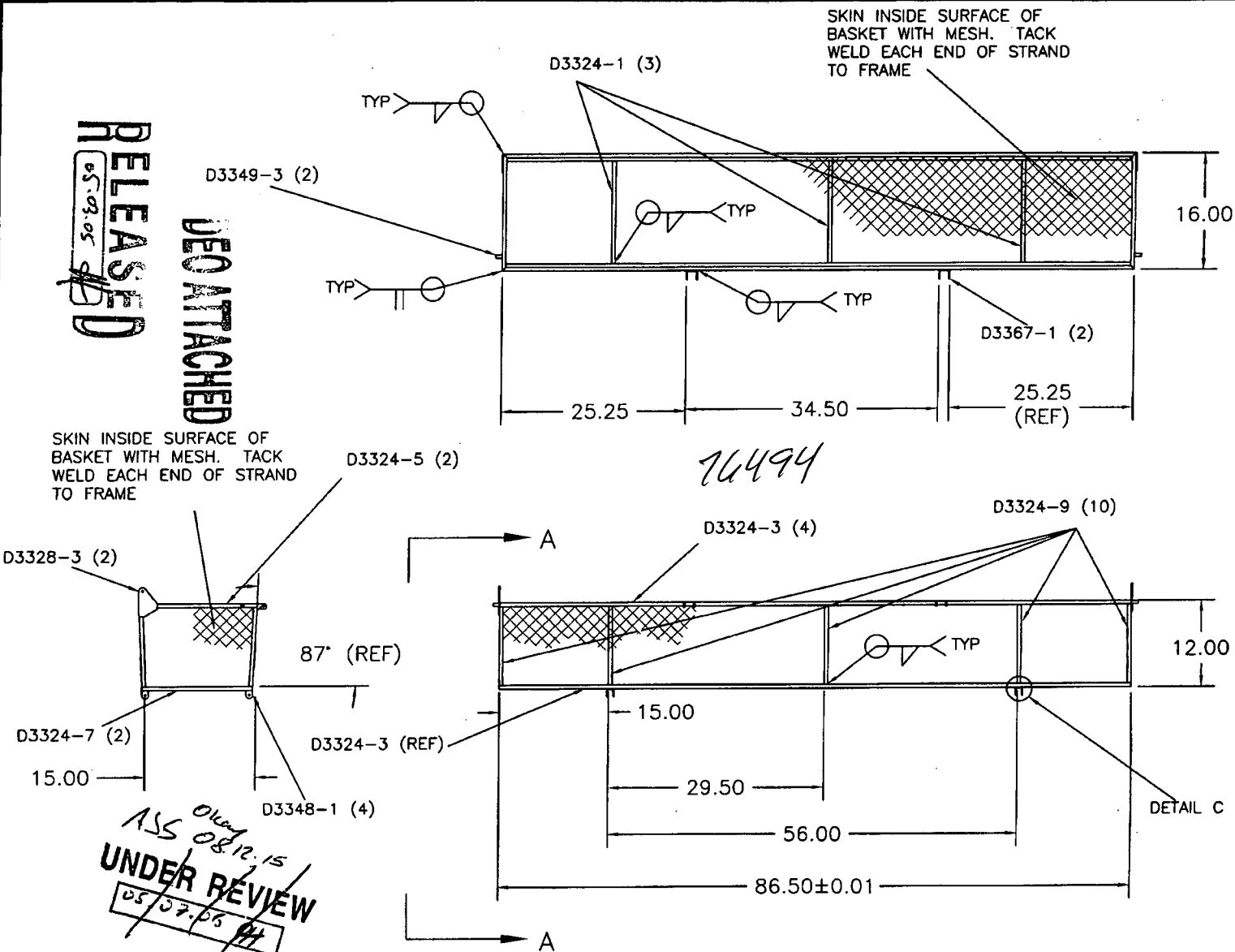
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

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|---------|----------|-------------|----------------------|-----------------------------|
| DESIGN | PH | DRAWN BY | PH | DART AEROSPACE LTD |
| CHECKED | PH | APPROVED | PH | HAWKESBURY, ONTARIO, CANADA |
| DATE | 05.03.04 | TITLE | BASKET BASE ASSEMBLY | REV. B |
| | | DRAWING NO. | D3324 | SHEET 2 OF 3 |
| | | SCALE | 1:20 | |



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED
05.03.05

DETACHED

UNDER REVIEW
05.07.05
05.08.12.15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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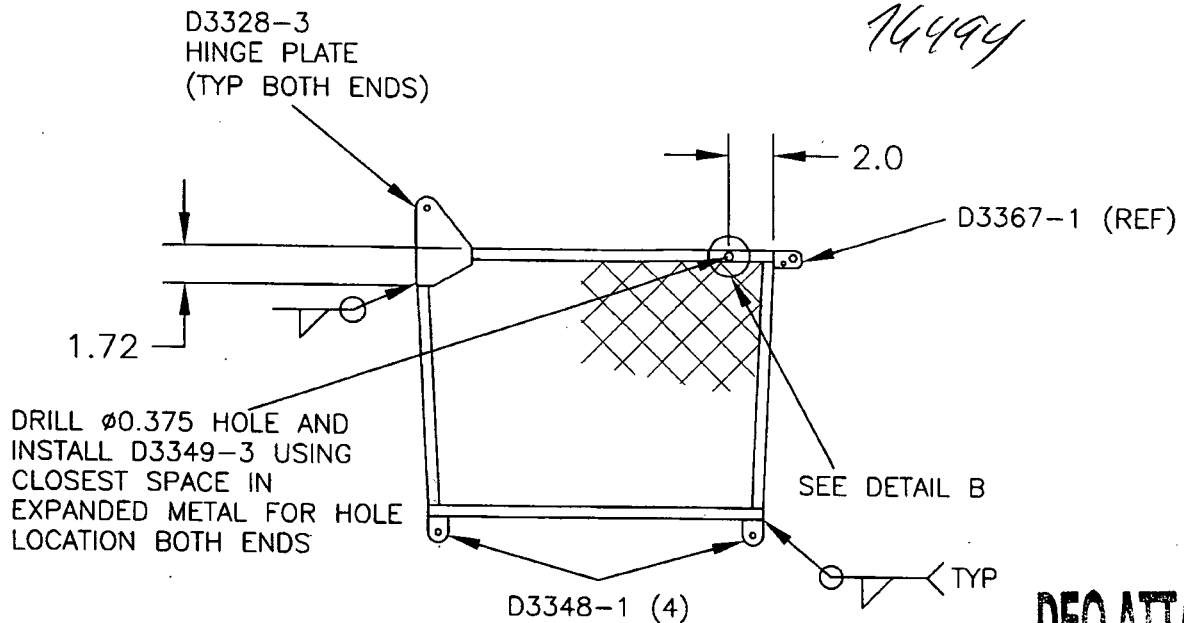
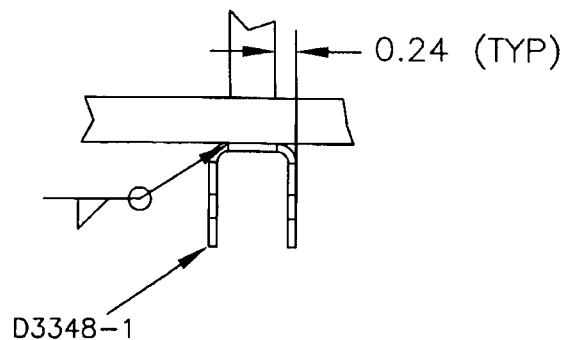
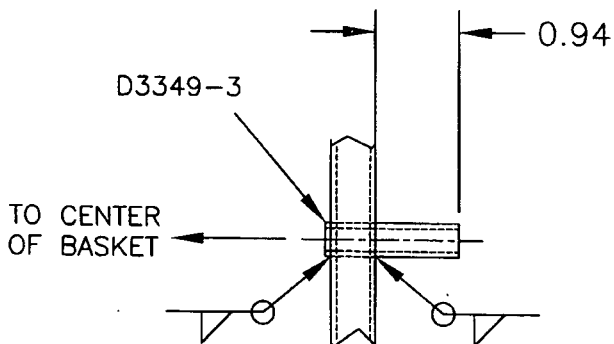
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NOTE: Date & initial all entries

DART

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|-------------------------------|--------------------------------|---------------------------------------------------|------------------------|
| DESIGN <i>PH</i> | DRAWN BY <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3324 | REV. B SHEET 3 OF 3 |
| DATE 05.03.04 | | TITLE BASKET BASE ASSEMBLY | SCALE 1:8 |

**DEO ATTACHED****RELEASED**
05.03.05

OK
ASS 08.12.15
UNDER REVIEW
05.07.05

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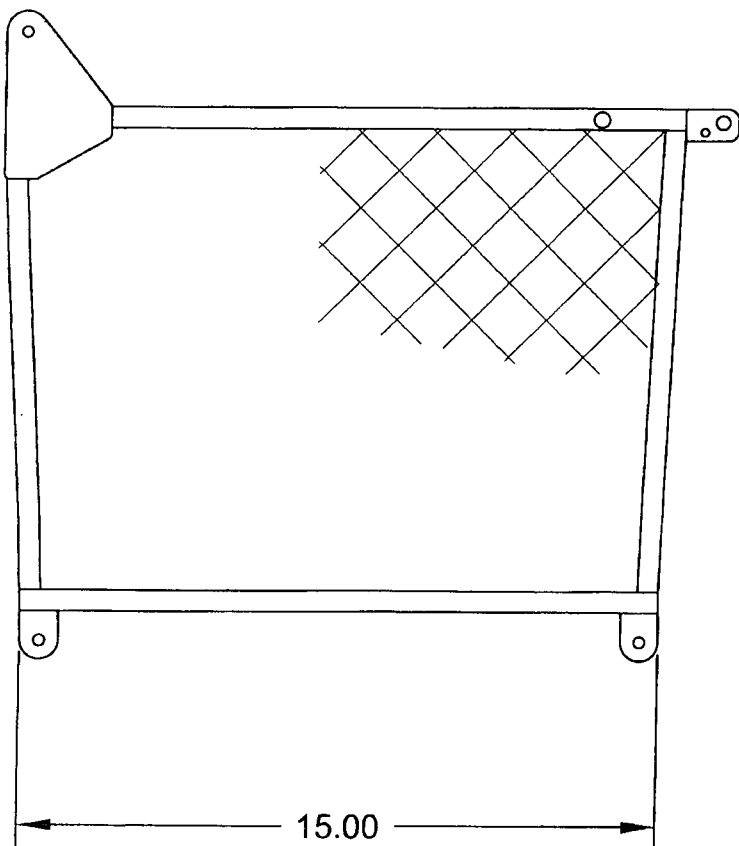
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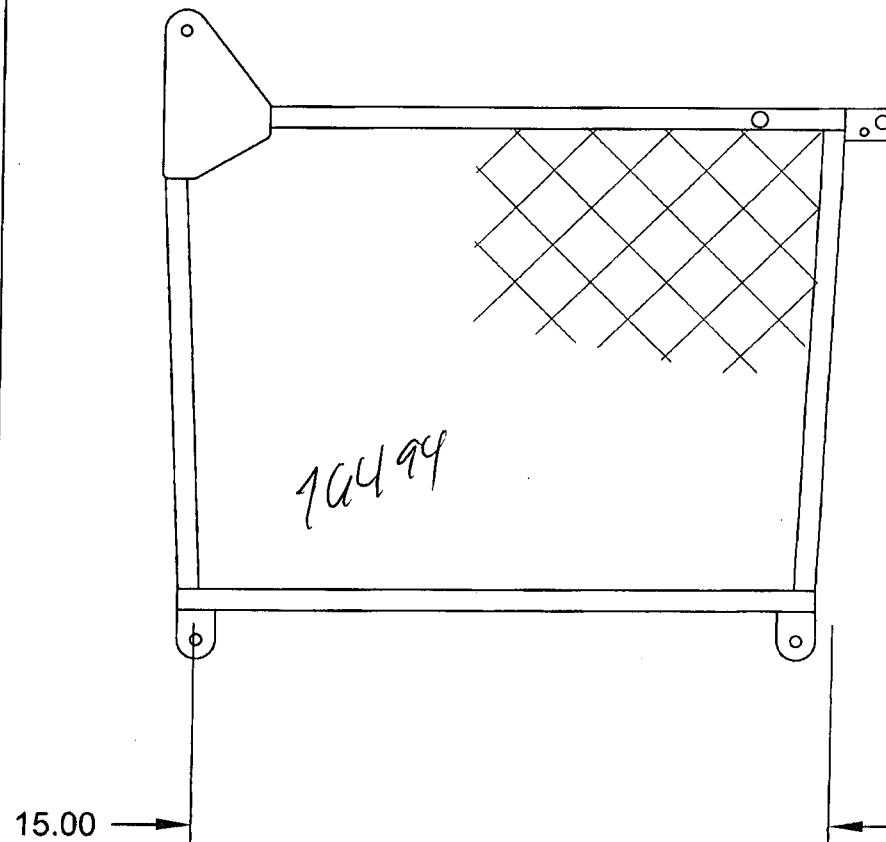
| | | | | | | | |
|----------------------|-------------------------------|------------------|-----------------------------------------|--|-------------------------|---------------------------|--------------|
| DRAWING NO. D3324 | TITLE BASKET BASE ASSEMBLY | REV. B | DART AEROSPACE LTD ENGINEERING ORDER | | D.E.O. NO. D3324-B-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN AJS | CHECKED | MFG. APPR. | APPROVED | | DE APPR. | | |
| DATE 08.11.28 | DATE 08.11.28 | DATE 08/12/01 | DATE 08/12/01 | | DATE 08.12.01 | | |

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



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